



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 53967




November 24, 2009 11:15:40 AM



Page 2

Item ID: D2873-045 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Nut Plate Assembly  
Start Date: 25/11/2009 Start Qty: 20.00  Cust Item ID:  
Required Date: 07/12/2009 Req'd Qty: 20.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	8809/11/29			20	0		
140  Small Fab Small Fab	Small Fab  Memo 1-Deburr □2- C'sink as per Dwg D2873	0.00 0.00	8809/11/30 (20)						
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	2) 50216/30			420	1		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53967

November 24, 2009 11:15:40 AM



Page 3

Item ID:	D2873-045	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Nut Plate Assembly					
Start Date:	25/11/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	07/12/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	MS	09/12/01		(20)	9		
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	161	09-12-1		(20)			
180  Small Fab Small Fab Small Fab	Small Fab  Memo 1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045	0.00 0.00							

09/12/01 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector






Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

November 24, 2009 11:15:40 AM

<b>Item ID:</b>	D2873-045	<b>Accept</b>		<b>Setup</b>	<b>Start</b>	
<b>Revision ID:</b>	A					
<b>Item Name:</b>	Nut Plate Assembly				<b>Stop</b>	
<b>Start Date:</b>	25/11/2009	<b>Start Qty:</b>	20:00		<b>Cust Item ID:</b>	
<b>Required Date:</b>	07/12/2009	<b>Req'd Qty:</b>	20:00		<b>Customer:</b>	
<b>Reference:</b>						

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				counter (430)	/		
200  Packaging Packaging	Identify as per dwg & Stock Location: <i>K-tubes Finishing</i>  Memo	0.00  0.00				<i>ml</i>	<i>09</i>	<i>12</i>	<i>02</i>
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>09/12/02</i> <i>mf 09-1</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November 24, 2009 11:15:46 AM

Page 1  
2

Work Order ID: 53967

Parent Item: D2873-045RevA

Parent Item Name: Nut Plate Assembly


Comments:

Start Date: 25/11/2009

Required Date: 07/12/2009

Start Qty: 20.00


Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	410.0000	40.0000			

*Eff 09/12/01*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	410	
110916	79	
112243	331	

*40*

M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	17.6095	4.7368			
---	--	-----------	----	--	--	-----	---	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	17.60947368	
105225	5.3	
→ 110829	12.3094737	

*4.7368 mkr 09/11/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

November 24, 2009 11:15:46 AM

Work Order ID: 53967



Parent Item: D2873-045RevA



Parent Item Name: Nut Plate Assembly

Start Date: 25/11/2009

Required Date: 07/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date: Issued	Status
MS20426AD4-6  Rivet		Purchased	No			180	Each	3,930.000	80.0000			

*809/12/01*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3930	
100151	27	
103395	14	
105144	88	
110139	3774	
2525	27	

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
80  
\_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53947
<b>Description:</b> Radius Block		<b>Part Number:</b>	D2873-5
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

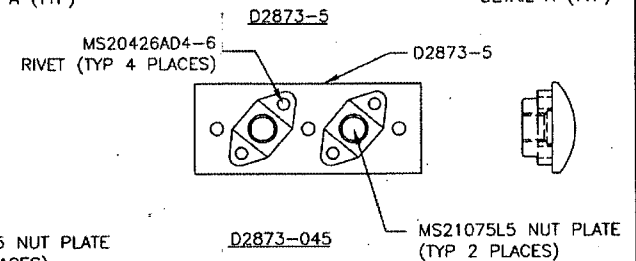
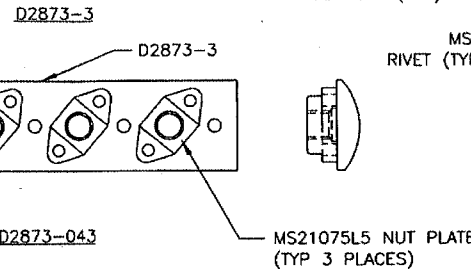
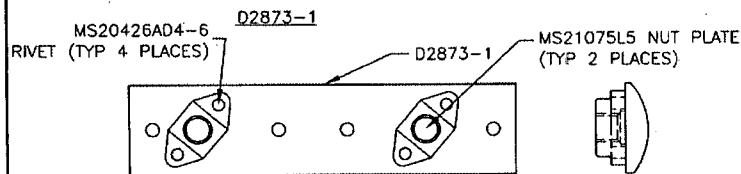
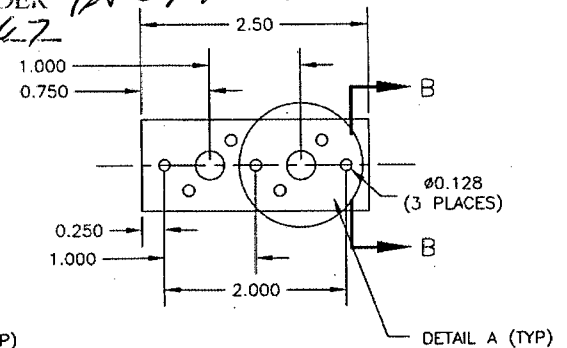
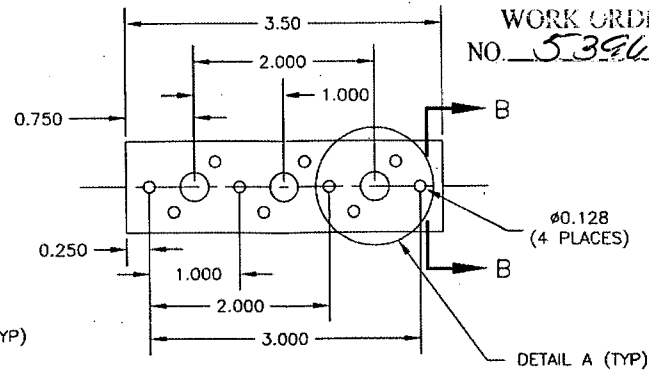
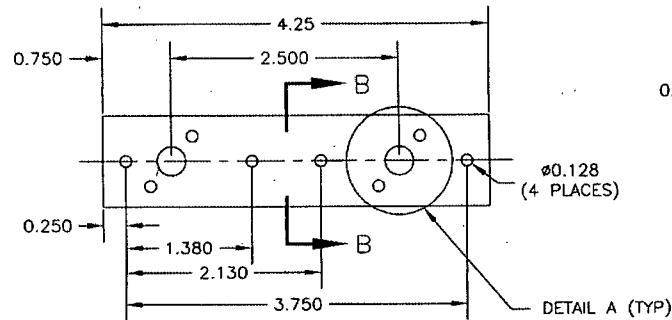
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.503	✓			
1.000	+/-0.010	0.997	✓			
0.750	+/-0.010	0.750	✓			
0.250	+/-0.010	0.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	0.132	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	0.319	✓			
1.000	+/-0.010	0.997	✓			
0.250	+/-0.010	0.250	✓			
0.061	+/-0.010	0.067	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.230 x 0.125	✓			

<b>Measured by:</b> DJP	<b>Audited by:</b> BB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/11/28	<b>Date:</b> 09/11/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	P/O D2873-045	KJ/JLM

WITHOUT NOTICE  
WORK ORDER NO. 53967 *PH 09-11-24*



#### D2873-1/-3/-5 RADIUS BLOCK

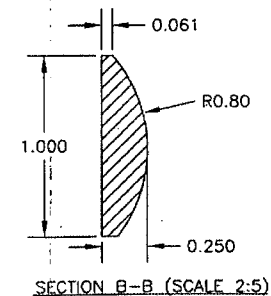
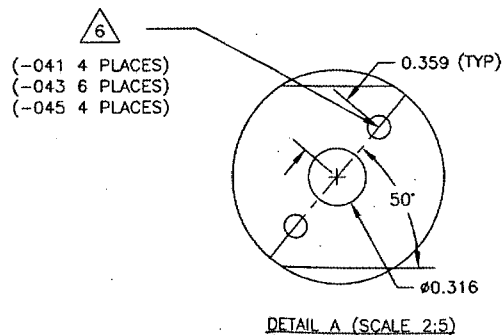
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED  
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	PH
CHECKED	DS	DS
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE
		4:5